

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009058**Date Inspected:** 29-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Xu Yumin, Liu Xiao Zhong, Zhan			<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No N/A
				<b>Delayed / Cancelled:</b>	Yes	No N/A
<b>Bridge No:</b>	34-0006			<b>Component:</b>	Tower and OBG Components	

**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector George Goulet was present during the times noted above for observations relative to the work being performed.

**OBG Trial Assembly Area**

This QA Inspector randomly observed the following work in progress in the trial assembly area:

1AAE/1AE joint, south side plate to side plate weld, and side plate T-rib stiffener to side plate welds – ZPMC performing MT.

1BE, east of panel point 12.5, at field joint – ZPMC performing numerous SMAW fillet welds at side plate I-rib stiffener to side plate welds and edge plate I-rib stiffener to edge plate welds. Welder was identified as 054467. ZPMC QC was identified as CWI Xu Yumin (QC1). The welding variables recorded by QC1 appeared to comply with WPS-B-P-2113-FCM-1.

2AE/2BE, panel points 13.5 to 17, ABF performing MT at the following locations: longitudinal diaphragm to bottom plate welds and upper floor beam web to upper flange welds.

At 2140 hours QC1 informed this QA Inspector that ZPMC would be performing RT in the trial assembly area at 2200 hours. This QA Inspector, George Goulet, left the area.

Bay 11

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## WELDING INSPECTION REPORT

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This QA Inspector randomly observed the following work in progress in Bay 11:

FCAW welding of weld joint WSTL3-4C/K-27 located on west tower, lift 3, corner backfill plate at skins D to E, diaphragm 89M. Welder was identified as 053310. ZPMC QC was identified as CWI Liu Shao Zhong (QC2). Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Shao Hai Long, who was not a CWI. The welding variables recorded by QC2 and QC2's assistant appeared to comply with WPS-B-T-4332-Tc-P4-F.

FCAW welding of weld joint WSTL3-4G/K-23 located on west tower, lift 3, corner backfill plate at skins D to E, diaphragm 99M. Welder was identified as 070212. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Shao Hai Long, who was not a CWI. The welding variables recorded by QC2 and QC2's assistant appeared to comply with WPS-B-T-4332-Tc-P4-F.

FCAW welding of weld joint WSTL3-4G/K-122 located on west tower, lift 3, corner backfill plate at skins D to E. Welder was identified as 070256. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-4332-Tc-P4-F.

FCAW welding of weld joint WSTL3-4I/K-22, 120 located on west tower, lift 3, corner backfill plate at skins D to E. Welders were identified respectively as 068206, 066491. ZPMC QC was identified as CWI Zhen Bo (QC3). The welding variables recorded by QC3 appeared to comply with WPS-B-T-4333-Tc-P4-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No relevant conversations on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 134-8257-0045, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Goulet, George	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon, Albert	QA Reviewer

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